

**Work Order ID 86988**

Friday, July 06, 2012 3:11:04 PM

**\*86988\***

Page 1

Item ID: D350-748-241TRN

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crosstube Turning Detail

Start Date: 7/6/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 7/12/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12-07-06* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D350-748-241

F

100

0.00

**\*100\***

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand &amp; install plugs on both ends as per Folio FA647

2-Turn first side as per Folio FA647

3- File transition lines smooth.

FOLIO REV:

DWG REV: *F*

110

QC1- Inspect dimensions to dimension sheet

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*mar L*  
*12/07/10**mar L*  
*12/07/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 86988**

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**\*86988\***

Page 2

Item ID: D350-748-241TRN

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Crosstube Turning Detail

Stop **\*NS2\***Start Date: 7/6/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 7/12/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

0.00

**\*120\***

Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA647  
2- File transition lines smooth.  
3-Scribe part # as per Dwg D350-748-241  
FOLIO REV: \_\_\_\_\_  
DWG REV: F

1 0

M.M.L  
12/07/11

130

QC1- Inspect dimensions to dimension sheet

0.00

**\*130\***

QC

Memo

0.00

Quality Control

1 0

M.M.L  
12/07/11

140

QC8- Inspect parts - second check

0.00

**\*140\***

QC

Memo

0.00

Quality Control

D4  
JW  
DP

12-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, July 06, 2012 3:11:04 PM

**\*86988\***

Page 3

Item ID: D350-748-241TRN

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crosstube Turning Detail

Start Date: 7/6/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 7/12/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

0.00

**\*150\***

Crosstubes

Large Fab

Memo

0.00

Crosstubes

1-DRILL HOLES FOR HEAT TREAT USING DT9806(HOLES MUST BE  
ALIGNED ON SAME LINE ON BOTH CUFFS)

- De 12/07/24

2-Grind machining marks

JW

12.7-27

160

Outsource process - Heat Treat

0.00

**\*160\***

Outsource1

Memo

0.00

Outsource process - Heat Treat

Issue P/O:

Heat Treat to min 180 KSI As per Dwg D350-748-241

Sand Blast tube after Heat Treat

Possibe Supplier: Vac Aero

Ensure Certificate of Conformity is attached

R1208-2

JTC

170

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

Ensure certificate of conformaty is attached

14

SP12-8-21

42/1/24 C

Purchase  
Issue PO  
Sandblast to remove scale only  
JTC

# Dart Aerospace Ltd

W/O: 86988		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

See Link NCR  
NCR 12-1915

Part No: D350-748-241TRN PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/09/21	160	Supplier did not send 12/21	12/09/21	Send for sandblasting to remove scale only Issue PO 17979 IMI	12/09/21			
				Receive + Inspect 12/9/21				

NOTE: Date & initial all entries

**Work Order ID 86988****\*86988\***

Page 4

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Cust Item ID:

Required Date: 7/12/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC6- Inspect dimensions to drawing

0.00

**\*180\***

QC

Memo

0.00

Quality Control

190

Packaging

0.00

**\*190\***

Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack  
Location: LG

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

Memo

0.00

Quality Control

RM 12-7-28

12/10/22

MCS 12-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, July 06, 2012 3:11:04 PM

Page 1

Work Order ID: 86988

Parent Item: D350-748-241TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 7/6/2012

Required Date: 7/12/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-03-06 DD verified by:ec  
 IPP Rev B Removed polish 08.04.02 EC verified by : DD  
 IPP Rev C Removed LPS-3 08.06.23 Ec verified by: DD IPP Rev D 11.02.24 as per dwg  
 rev.F DD verf: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6015-125 Crosstube Material		Manufactured	No			120	Each	28.0000	1	1			

Location

Loc Qty

Loc Code

HALL

28

61380

4

72511

24

man, l 12/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 86988
<b>Description:</b> Crosstube Assembly (AS350/355 High Aft)		<b>Part Number:</b> D350-748-241
<b>Inspection Dwg:</b> D350-748-241 <b>Rev:</b> F		<b>Page 1 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.243	/		vern	CNC-08
	2.180	+0.005/-0.000	2.182	/		↓	
	2.180	+0.005/-0.000	2.185	/			
	2.208	+0.005/-0.000	2.212	/			
	2.234	+0.005/-0.000	2.236	/			
	2.253	+0.005/-0.000	2.256	/			
	2.272	+0.005/-0.000	2.277	/			
	2.299	+0.005/-0.000	2.306	/			
						↓	
	0.063	+/-0.010	.063	/		vern	CNC-08
	4.26	+/-0.030	4.26	/		"	
	R0.063	+/-0.010	.063	/		R6	
	R0.50	+/-0.030	.500	/		"	
SIDE B	2.240	+0.005/-0.000	2.244	/		vern	CNC-08
	2.180	+0.005/-0.000	2.183	/		↓	
	2.180	+0.005/-0.000	2.185	/			
	2.208	+0.005/-0.000	2.212	/			
	2.234	+0.005/-0.000	2.236	/			
	2.253	+0.005/-0.000	2.256	/			
	2.272	+0.005/-0.000	2.277	/			
	2.299	+0.005/-0.000	2.306	/			
						↓	
	0.063	+/-0.010	.063	/		vern	CNC-08
	4.26	+/-0.030	4.26	/		"	
	R0.063	+/-0.010	.063	/		R6	
	R0.50	+/-0.030	.500	/		"	
	122.70	+/-0.060	122.70	/		tape	LB-22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

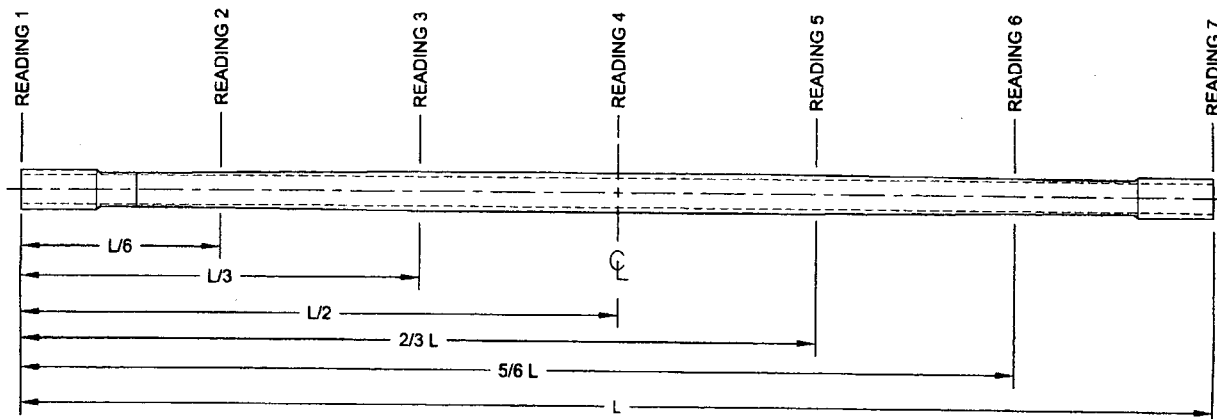
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 20988
<b>Description:</b> Crosstube Assembly (AS350/355 High Aft)	<b>Part Number:</b> D350-748-241
<b>Inspection Dwg:</b> D350-748-241 Rev: F	<b>Page 2 of 2</b>

### WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation $\Delta w$ (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.136	.121	.114	.130	.022	0.030"
READING 2 L=	.116	.100	.114	.135	.035	
READING 3 L=	.146	.159	.166	.149	.020	
READING 4 L=	.159	.163	.160	.148	.015	
READING 5 L=	.161	.168	.149	.144	.024	
READING 6 L=	.114	.124	.129	.117	.015	
READING 7 L=	.118	.120	.131	.129	.013	

#### Calibration Result

Actual Block Thickness: 100-200

Sitiescan 250 Measured Thickness: 100-200

<b>Measured by:</b> KC	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 12-7-18	<b>Date:</b> 12-7-20	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue (P/O D350-748-201)	KJ/JLM	
B	12.02.02	Dwg Rev updated	KJ	
C	12.06.04	Wall thickness form added	KJ	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Item	Qty -241	Part Number	Description
1	X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6015-125	CROSSTUBE (OR D6018-125)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

#### GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6018-125  
FINISHED LENGTH = 122.700±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF  
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING  
LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER  
BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO  
VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE,  
CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,  
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.  
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE  
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO  
CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT  
NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH TUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN  
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

#86988

RELEASED  
R 2011-01-08  
NP

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); ADD TOLERANCES (ZN C6-3, D2-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6018-125 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR			
DATE	10.11.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. F  
D350-748-241 SHEET 1 OF 4  
TITLE SCALE  
CROSSTUBE (AS 350/355 HI AFT) NTS

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W/O:		WORK ORDER CHANGES					
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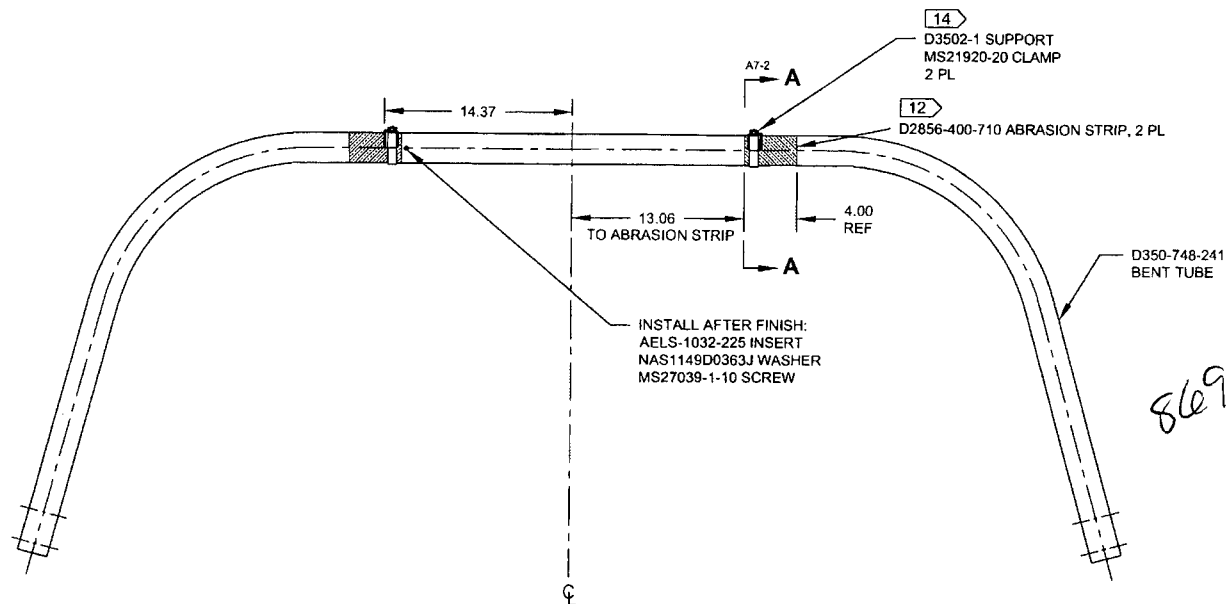
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

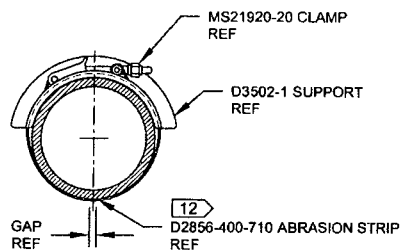
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**NOTE:** Date & initial all entries





**D350-748-241  
ASSEMBLY DETAIL**



**SECTION A-A** D4-2  
SCALE 4X

**RELEASED**  
R 2011-05 19 D

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. F
MFG. APPR.	90	D350-748-241	SHEET 2 OF 4
APPROVED	90	TITLE	SCALE
DE APPR.	90	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	10.11.23	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

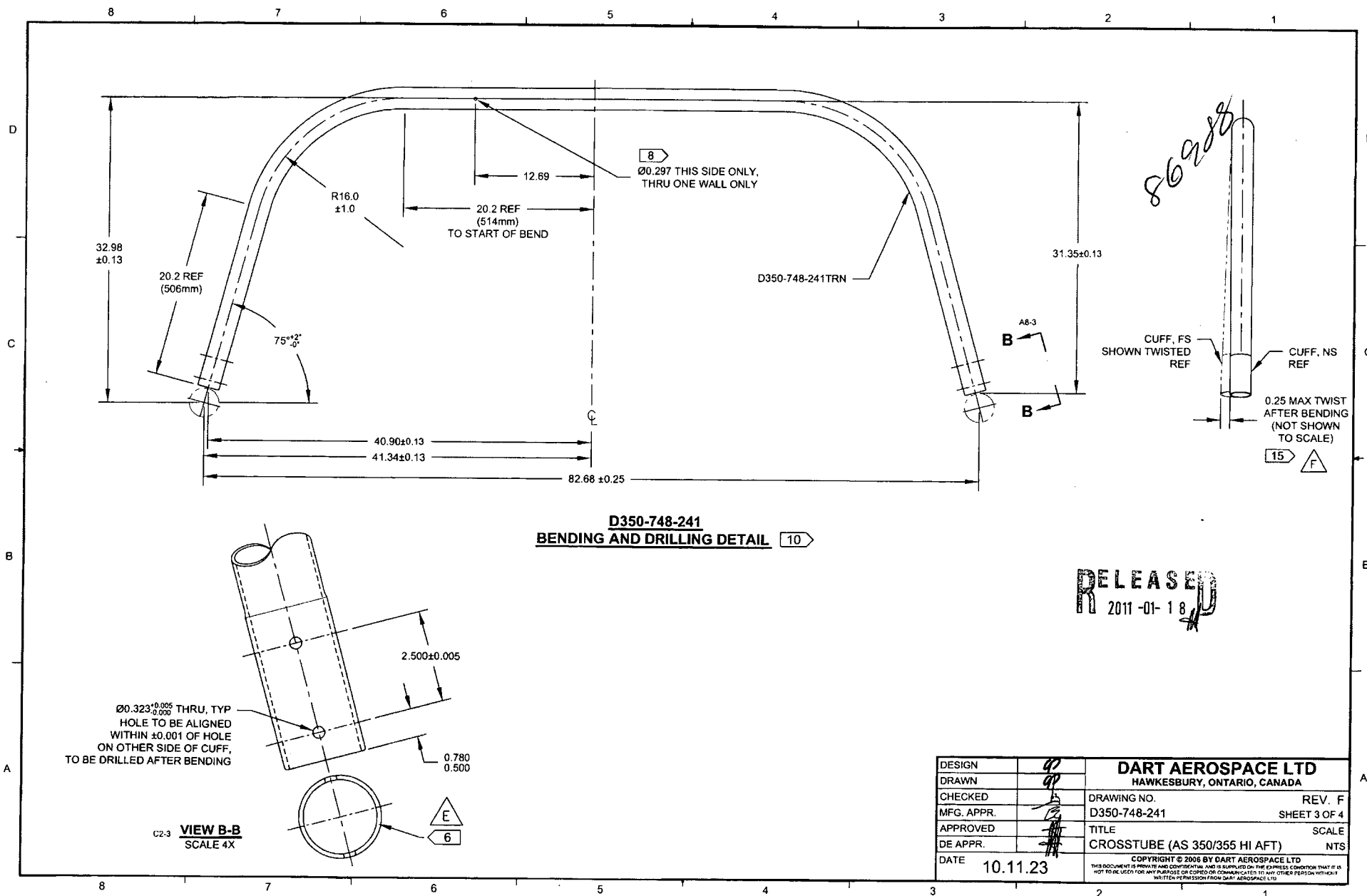
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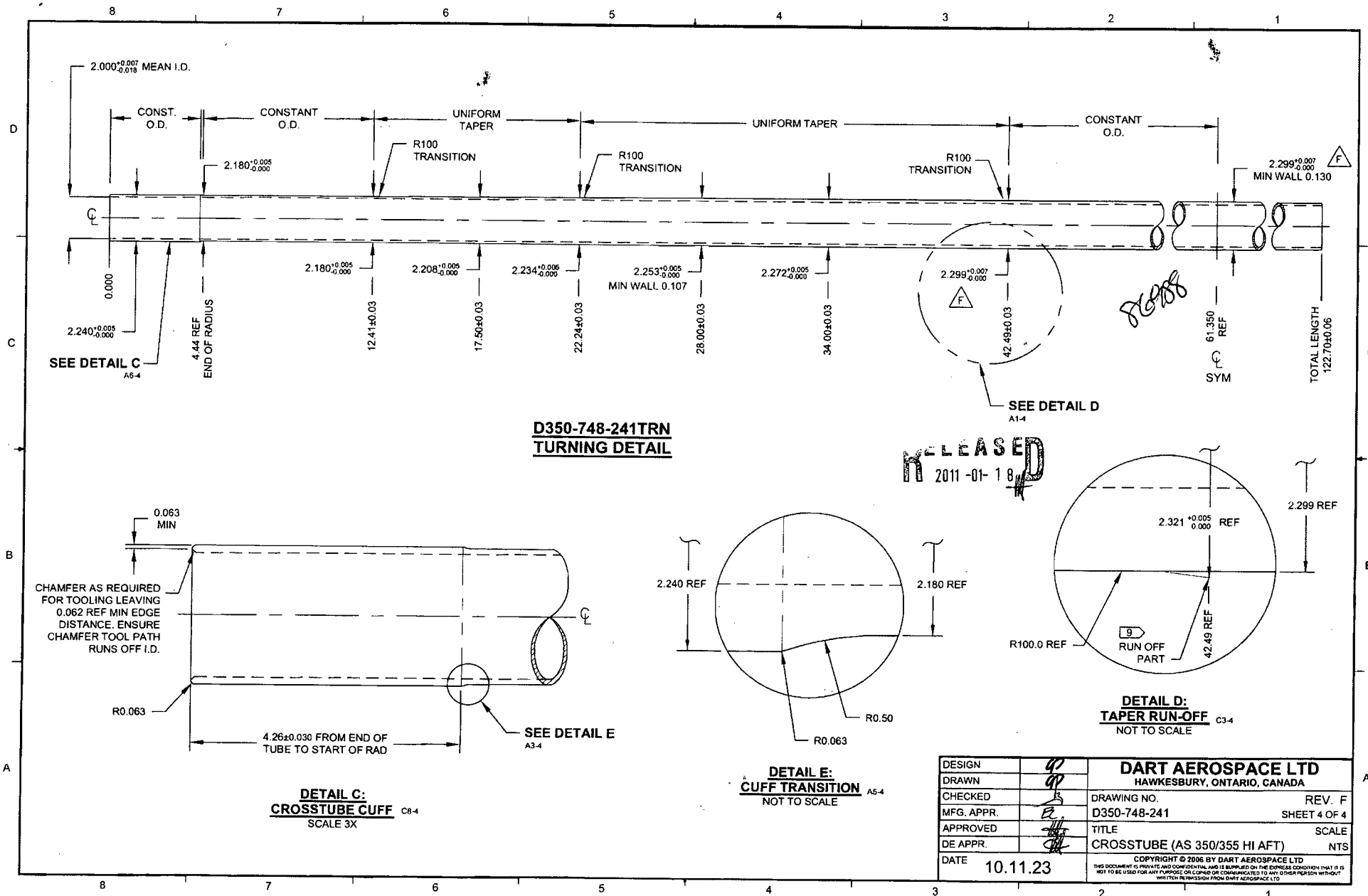
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief-Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Packing I**

Sales Order Num

7

Sales Order

Aug 8,

**LAB****1000 E. MERMAID LANE  
WYNDMOOR, PA 19038**

Voice: 215-233-2600

Fax: 215-233-5653

Sold To:

**DART AEROSPACE  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7**

Ship To:

**DART AEROSPACE  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7**

Customer ID	PO Number	Payment Terms
DARA	PO17601	Net 30 Days
Ship Via	Process	
R & L CARRIER		

Quantity	Item	Description	Total Shipped	This Shipm
1.00	✓	1 PC. 86987 D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMD 2759-1C) SANDBLAST TUBE AFTER HEAT TREAT		
1.00	✓	1 PC. 86988 D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMD 2759-1C) SANDBLAST TUBE AFTER HEAT TREAT		
1.00	✓	1 PC. 84668 D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMD 2759-1C) SANDBLAST TUBE AFTER HEAT TREAT		

88 12-8-21

COMMENTS

SHIPPED BY, SIGNATURE  
METLAB

DATE

RECEIVED BY, SIGNATURE  
DART AEROSPACE

DATE

# Packing I

Sales Order Num

7

Sales Order

Aug 8,

LAB

1000 E. MERMAID LANE  
WYNDMOOR, PA 19038

Voice: 215-233-2600

Fax: 215-233-5653

Sold To:

DART AEROSPACE  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

Ship To:

DART AEROSPACE  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

Customer ID	PO Number	Payment Terms
DARA	PO17601	Net 30 Days
Ship Via	Process	
R & L CARRIER		

Quantity	Item	Description	Total Shipped	This Shipm
1.00	✓	1 PC. 84672 D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMD 2759-1C) SANDBLAST TUBE AFTER HEAT TREAT		
1.00	✓	1 PC. 84669 D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMD 2759-1C) SANDBLAST TUBE AFTER HEAT TREAT		
1.00	✓	1 PC. 84677 D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMD 2759-1C) SANDBLAST TUBE AFTER HEAT TREAT 180 POUNDS TOTAL		

SEP 12-8-21

COMMENTS

SHIPPED BY, SIGNATURE  
METLAB

DATE

RECEIVED BY, SIGNATURE  
DART AEROSPACE

DATE





1000 E. Mermaid La., Wyndmoor (Phila.) PA 19038-8093  
Tel. (215) 233-2600 Fax (215) 233-5653

# Invoice

Invoice Num

Q1142

Invoice D

Aug 16, 20

**Sold To:**

DART AEROSPACE  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

**Ship To:**

DART AEROSPACE  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

Customer ID		Customer PO		Payment Terms	
DARA		PO17601		Net 30 Days	
Shop Order No.		Shipping Method		Ship Date	Due Date
73369		R & L CARRIER		8/16/12	9/15/12
Quantity	Item	Description		Unit Price	Extensio
1		1 PC. 86987 D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMD 2759-1C) SANDBLAST TUBE AFTER HEAT TREAT		205.000	20
1		1 PC. 86988 D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMD 2759-1C) SANDBLAST TUBE AFTER HEAT TREAT		205.000	20
1		1 PC. 84668 D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMD 2759-1C) SANDBLAST TUBE AFTER HEAT TREAT		205.000	20
1		1 PC. 84672		205.000	20

ANY DISCREPANCIES MUST BE REPORTED WITHIN 10 DAYS AFTER RECEIPT.

**We accept AMEX, Visa & Master Card**



Heat Treating and Metallurgical Consulting

Subtotal	Contir
Shipping/Handling	
Total Invoice Amount	Contir
Payment Received	
<b>TOTAL</b>	Contir

Visit our Web Site: <[www.thomasregister.com/metlab/](http://www.thomasregister.com/metlab/)>



1000 E. Mermaid La., Wyndmoor (Phila.) PA 19038-8093  
Tel. (215) 233-2600 Fax (215) 233-5653

# Invoice

Invoice Num

0114

Invoice D

Aug 16, 20

**Sold To:**

DART AEROSPACE  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

**Ship To:**

DART AEROSPACE  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

Customer ID		Customer PO	Payment Terms	
DARA		PO17601	Net 30 Days	
Shop Order No.		Shipping Method	Ship Date	Due Date
73369		R & L CARRIER	8/16/12	9/15/12
Quantity	Item	Description	Unit Price	Extensi
1		D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMD 2759-1C) SANDBLAST TUBE AFTER HEAT TREAT 1 PC. 84669	205.000	20
1		D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMD 2759-1C) SANDBLAST TUBE AFTER HEAT TREAT 1 PC. 84677	205.000	20
		D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMD 2759-1C) SANDBLAST TUBE AFTER HEAT TREAT 180 POUNDS TOTAL		

ANY DISCREPANCIES MUST BE REPORTED WITHIN 10 DAYS AFTER RECEIPT.

**We accept AMEX, Visa & Master Card**




Heat Treating and Metallurgical Consulting

Subtotal	1,23
Shipping/Handling	
Total Invoice Amount	1,23
Payment Received	
<b>TOTAL</b>	<b>1,23</b>

Visit our Web Site: <[www.thomasregister.com/metlab/](http://www.thomasregister.com/metlab/)>

# North American Free Trade Agreement Certificate of Origin

Please print or type

1. Exporter's Name and Address:  <b>Metlab</b> <b>1000 E. Mermaid Lane</b> <b>Wyndmoor, PA 19038</b>  Tax Identification Number: <b>23-2973306</b>		2. Blanket Period: (dd/mm/yyyy)  From: <b>01/01/2012</b> To: <b>31/12/2012</b>			
3. Producer's Name and Address:  <b>Metlab</b> <b>1000 E. Mermaid Lane</b> <b>Wyndmoor, PA 19038</b>  Tax Identification Number: <b>23-2973306</b>		4. Importer's Name and Address:  <b>Dart Aerospace</b> <b>1270 Aberdeen Street</b> <b>Hawkesbury, ON K6A 1K7</b> <b>CANADA</b>  Tax Identification Number:			
5.  Description of Good(s)	6.  HS Tariff Classification Number	7.  Preference Criterion	8.  Producer	9.  Net Cost	10.  Country of Origin
  <b>Heat Treatment Services</b>	  <b>8483.401</b>	  <b>C</b>	  <b>Yes</b>	  <b>No</b>	  <b>USA</b>
11. I CERTIFY THAT:					
<ul style="list-style-type: none"> <li>* the Information on this document is true and accurate and I assume the responsibility for proving such representations. I understand that I am liable for any false statements or material omissions made on or in connection with this document;</li> <li>* I agree to maintain, and present upon request, documentation necessary to support this Certificate, and to inform, in writing, all persons to whom the Certificate was given of any changes that would affect the accuracy or validity of this Certificate;</li> <li>* the goods originated in the territory of one or more of the Parties, and comply with the origin requirements specified for those goods in the North American Free Trade Agreement, and unless specifically exempted in Article 411 or Annex 401, there has been no further production or any other operation outside the territories of the Parties; and</li> <li>* this Certificate consists of <u>One (1)</u> page, including all attachments.</li> </ul>					
Authorized Signature:  			Company: <b>Metlab</b>		
Name: <b>Mark Podob</b>			Title: <b>Vice President</b>		
Date: (mm/dd/yyyy) <b>8/16/2012</b>		Telephone: <b>215-233-2600</b>		Fax: <b>215-233-5653</b>	



1000 E. Mermaid Ln., Wyndmoor (Phila.) PA 19038-8093  
Tel. (215) 233-2600 Fax (215) 233-5663

# ORDER ACKNOWLEDGEMENT

613 632 1053

E-MAILED TO: \_\_\_\_\_

FAXED TO: \_\_\_\_\_

QP-4.722-01

Rev A 5/10/10

CUSTOMER: <u>Dart Aerospace</u>	PO NUMBER: <u>P017601</u>
DATE MATERIAL RECEIVED: <u>8/8/2012</u>	METLAB QUOTE NUMBER: <u>N/A</u> Or, MINIMUM STD ORDER(CHECK) _____
ESTIMATED SHIP DATE: <u>8/15/12</u>	METLAB S.O. NUMBER: <u>73369</u>

THANK YOU FOR YOUR ORDER. WE WILL MAKE OUR BEST EFFORT TO SHIP YOUR ORDER ON OR BEFORE THE ESTIMATED SHIP DATE SHOWN ABOVE. IF YOU NEED TO CONTACT US REGARDING THIS ORDER, PLEASE REFERENCE THE METLAB S.O. NUMBER SHOWN ABOVE.

QUOTATION MISSING? ☒ OK TO PROCESS WITHOUT DN

PURCHASE ORDER MISSING? \_\_\_\_\_ OK TO START PROCESSING WITHOUT \_\_\_\_\_

NOTE THAT WE NEED THE FOLLOWING INFORMATION IN ORDER TO COMPLETE YOUR ORDER AND TO MEET THE PROMISED SHIP DATE:

TECHNICAL INFORMATION REQUIRED(LIST) : \_\_\_\_\_ ON HOLD : YES \_\_\_\_\_ NO \_\_\_\_\_

OTHER INFORMATION OR CLARIFICATION: \_\_\_\_\_ ON HOLD : YES \_\_\_\_\_ NO \_\_\_\_\_

RELEASED FOR PROCESSING BY: DN DATE: 8/8/12

ACKNOWLEDGED BY: \_\_\_\_\_

TODAY'S DATE: \_\_\_\_\_

SHIPPED DATE: \_\_\_\_\_

THIS ORDER IS ACKNOWLEDGED WITH THE UNDERSTANDING THAT THE ABOVE PURCHASE ORDER IS IN ACCORDANCE WITH METLAB'S TERMS AND CONDITIONS OF SALE AS SUBMITTED AT THE TIME OF THE ABOVE QUOTATION.



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO17601**

Purchase Order Date 8/2/2012

PO Print Date 8/2/2012

Page Number 1 of 2

Order From :

VU-MET001

METLAB  
1000 E. MERMAID LANE  
WYNDMOOR, PA 19038  
USA

Contact Name  
Vendor Phone 215-233-2600  
Vendor Fax 215-233-5653  
Vendor Account Nbr

Buyer Brigitte Golden  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency USD  
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	86987 ✓	D350-748-241TRN Crosstube	8/13/2012 Yes	1.00	Day & Ross ppd	\$205.0000	\$205.0
		Special Inst: HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMS 2759-1C) SAND BALST TUBE AFTER HEAT TREAT CERTIFICATIONS					
2	86988 ✓	D350-748-241TRN Crosstube	8/13/2012 Yes	1.00	Day & Ross ppd	\$205.0000	\$205.0
		Special Inst: SAME AS ABOVE					
3	84668 ✓	D350-748-241TRN Crosstube	8/13/2012 Yes	1.00	Day & Ross ppd	\$205.0000	\$205.0
		Special Inst: SAME AS ABOVE					

8/12/8-21

No substitution or deviation without  
consent.

Certificate of Conformity or Material  
Certification required - YES NO

Change Nbr: 1

Change Date: 8/2/2012



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO17601**

Purchase Order Date 8/2/2012

PO Print Date 8/2/2012

Page Number 2 of 2

**Order From :**

VU-MET001

METLAB  
1000 E. MERMAID LANE  
WYNDMOOR, PA 19038  
USA

**Contact Name**

**Vendor Phone** 215-233-2600

**Vendor Fax** 215-233-5653

**Vendor Account Nbr**

**Buyer**

Brigitte Golden

**Requisition Nbr**

**Tax Resale Nbr**

10127-2607

**Terms**

Net 30

**Currency**

USD

**FOB**

Destination-Collect

4	84672 ✓	D350-748-241TRN Crosstube	8/13/2012	1.00	Day & Ross ppd	\$205.0000	\$205.0
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Yes

**Special Inst:** Same As above

5	84669 ✓	D350-748-241TRN Crosstube	8/13/2012	1.00	Day & Ross ppd	\$205.0000	\$205.0
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Yes

**Special Inst:** Same as above

6	84677 ✓	D350-748-241TRN Crosstube	8/13/2012	1.00	Day & Ross ppd	\$205.0000	\$205.0
---	---------	------------------------------	-----------	------	----------------	------------	---------

Yes

**Special Inst:** Same as above

**PO Total:** \$1,230.0

8/28-21

**Change Nbr:** 1

**Change Date:** 8/2/2012

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required - YES NO

## Brigitte Golden

**From:** Mark Podob <mpodob@metlabheattreat.com>  
**Sent:** Thursday, August 02, 2012 10:15 AM  
**To:** Doris Funches; Dan Krackovic; Eugene Roberts  
**Cc:** Brigitte Golden  
**Subject:** FW: New PO17601 from Dart  
**Attachments:** D350-748-241-RevF.pdf; PO17601 Metlab.pdf  
**Importance:** High

New P.O. from Dart.

Mark Podob  
Vice President, Marketing and Sales  
Metlab  
1000 E. Mermaid Lane  
Wyndmoor, PA 19038  
215-233-2600 Ext. 232  
(F) 215-233-5653  
[mpodob@metlabheattreat.com](mailto:mpodob@metlabheattreat.com)

This message and any attachments are intended for the individual or entity named above. If you are not the intended recipient, please do not forward, copy, print, use or disclose this communication to others; also please notify the sender replying to this message and then delete it from your system.

---

**From:** Brigitte Golden [<mailto:bgolden@dartaero.com>]  
**Sent:** Thursday, August 02, 2012 9:59 AM  
**To:** Mark Podob  
**Cc:** 'Linda Lacelle'  
**Subject:** New PO17601 from Dart  
**Importance:** High

Good Morning Mark!

Please find attached new PO for 6 crosstubes to be heat treated.

They are leaving today with Day & Ross this afternoon, tracking # OTT 19872092

Thank You

*Brigitte Golden*

Order Processing

**DART AEROSPACE Ltd.**

1270 Aberdeen Street  
Hawkesbury Ontario  
Canada K6A 1K7  
**Tel: (613) 632-5200 Ext 224**  
**Fax: (613) 632-1053**

[bgolden@dartaero.com](mailto:bgolden@dartaero.com)



Please consider your environmental responsibility before printing this e-mail

**From:** Brigitte Golden [<mailto:bgolden@dartaero.com>]  
**Sent:** Friday, July 27, 2012 11:19 AM  
**To:** 'mpodob@metlabheattreat.com'  
**Cc:** 'Linda Lacelle'  
**Subject:** PO17555 from Dart

Please find attached the PO  
Thank You

---

**From:** Linda Lacelle [<mailto:llacelle@dartaero.com>]  
**Sent:** Thursday, July 26, 2012 2:36 PM  
**To:** [mpodob@metlabheattreat.com](mailto:mpodob@metlabheattreat.com)  
**Cc:** Brigitte Golden  
**Subject:** more tubes

Hi Mark,

We will be shipping out 9 tubes tomorrow for heat treat. Another batch should follow end of next week. As always, I need these asap..

Thx!

Linda Lacelle  
Production manager  
Dart Aerospace





Commercial Invoice:145

**Ship From:** Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Canada  
Tel # 1.613.632.5200  
GST # RT101272607

**Ship To: METLAB**  
1000 E Mermaid LN  
Wyndmoor  
PA, 19038 US

**ATTN: Mark Podob**  
**PH#** 215 233 2600

**Date:** 2-Aug-12 **P.O. #** 17555

**Broker: UPS SCS**  
**PH#: 800 443-6379**

**Ship Via:** Day & Ross PPD **FOB:Origin**

Item	Part Number / Product Description	Tariff Class.	Quantity	Unit Price	Total
1	Crosstube D350-748-241	8803.20	6	\$ 1,250.00	\$ 7,500.0
2					
3					
4					

*All Prices are in US Dollars*

*All of the above parts were made in Canada unless otherwise indicated*  
**THIS IS A CUSTOMS INVOICE ONLY**


Sub Total \$7,500.00

Total \$7,500.00

**Amount Due: \$7,500.00**

**Dart Aerospace Ltd.**  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Canada  
Tel.: 1.613.632.5200  
Fax: 1.613.632.1185  
GST # RT101272607

NIR R-500048-5

<b>BILLER INIT.</b> (INITIALES PROPRIETAIRES) A LA FACTURATION	<b>OFF UNIT</b> DECHARGE DU VEHICULE NO.	<b>NO. OF PIECES</b> QUANTITE DE MORCEAUX	<b>INIT</b> UNIT
	<b>ON UNIT</b> CHARGE DANS VEHICULE NO.	<b>NO. OF PIECES</b> QUANTITE DE MORCEAUX	<b>INIT</b> UNIT



**STRAIGHT BILL OF LADING - 1.866.DAY.ROSS**

DATE			LEVEL OF SERVICE		C.O.D		Pick Up Information	
MONTH	DAY	YEAR	<input type="checkbox"/> GENERAL		AMOUNT	CURRENCY: <input type="checkbox"/> CDN <input type="checkbox"/> U.S.	Telephone Number:	Contact Name:
08	2	12	<input type="checkbox"/> PRIVATE RESIDENCE PICK UP <input type="checkbox"/> PRIVATE RESIDENCE DELIVERY <input type="checkbox"/> PALLETS BEING RETURNED <input type="checkbox"/> HAZARDOUS GOODS* <input type="checkbox"/> APPOINTMENT DELIVERY (DATE/TIME)		<input type="checkbox"/> TAILGATE PICK-UP <input type="checkbox"/> HEATED SERVICE <input type="checkbox"/> TRADE SHOW PU <input type="checkbox"/> INBOND		<input type="checkbox"/> TAILGATE DELIVERY <input type="checkbox"/> TEMPERATURE CONTROL (TL ONLY) <input type="checkbox"/> TRADE SHOW DELIVERY	
*this shipment contains dangerous goods as set out in the attached shipper's declaration					REQUESTED BY: <input type="checkbox"/> SHIPPER <input type="checkbox"/> CONSIGNEE <input type="checkbox"/> BILL TO <input type="checkbox"/> THIRD		Ready Date & Time: Closing Time:	
SHIPPER					CONSIGNEE			
DAY & ROSS ACCT. NO. 038326 TEL NO. 6136325200					DAY & ROSS ACCT. NO. TEL NO. 215233			
SHIPPER'S NAME DART AEROSPACE					CONSIGNEE'S NAME Metlab			
PICK UP ADDRESS 1270 Aberdeen St Hawkesbury ON K6A1K7					DELIVERY ADDRESS Mark Podob 1000 E. Mermaid Lane Wyndmoor PA 190			
CITY PROV. COUNTRY POSTAL CODE					CITY PROV. COUNTRY POSTAL CODE			
METHOD OF PAYMENT					OTHER BILL TO PARTICULARS			
<input checked="" type="checkbox"/> PREPAID <input type="checkbox"/> COLLECT					BILL TO:			
<input type="checkbox"/> CASH IN ADVANCE AMOUNT CURRENCY: <input type="checkbox"/> CDN					BILL TO ADDRESS			
<input type="checkbox"/> THIRD PARTY BILL TO ACCOUNT NUMBER								
<input type="checkbox"/> VISA <input type="checkbox"/> M.C. <input type="checkbox"/> AMX EXPIRY DATE								
CARD NO.					GST: CITY PROV. COUNTRY POSTAL CODE			
SPOT QUOTE NO.					ROUTING OR SPECIAL INSTRUCTIONS			
NO. OF PCS. DESCRIPTION OF ARTICLES AND SPECIAL MARKS					WEIGHT DECLARED VALUE DIMENSIONS			
3 Aircraft parts cross tube cardboard cartons					<input checked="" type="checkbox"/> LBS <input type="checkbox"/> KGS 180 127x13x7			
ALL USED HOUSEHOLD GOODS AND PERSONAL EFFECTS SHIPPED AT SHIPPER'S RISK OF DAMAGE					The carrier's maximum liability is limited by the TER			

The carrier's maximum liability is limited by the **TERMS AND CONDITIONS** of the Bill of Lading. (See Term and Condition No. 5)

PICK-UP DATE	08-02-2012	NO. OF PCS.	
DAY & ROSS DRIVER	Dennis	PURCHASE ORDER	
POWER NO.	270604	TRAILER NO.	1

St



# Manufacturing Inc.

## Packing Slip

772 MAIN STREET E., P.O. BOX 3,  
HAWKES BAY, ONTARIO K6A 2R4

**TEL: (613) 632-0921**  
**FAX: (613) 632-2681**

Date	Page
Sep 24, 2012	1
Shipment Number	
SH005312	

So!

**Ship To:**

DEPT. OF POLICE  
100 ADAM DEEN STREET  
HAWKESBURY, ON K6A 1K7  
CANADA

**DART AEROSPACE**  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7  
CANADA

PO Number 17979	Customer No. DAR100	Order No. OR005146	Ship Via	Order Date September 24, 2012
--------------------	------------------------	-----------------------	----------	----------------------------------

Item Number	Description	Qty. Ordered	UOM	Qty. Shipped	Qty. Backord.
MS-12.7	DART AEROSPACE - SANDBLAST 9 PIPES	9.00	EA	9.00	0.00

## Comments

Total weight:

Total packages:

**\*\*\* THANK YOU FOR YOUR BUSINESS \*\*\***

